

Work Order ID 54755

December 21, 2009 9:04:27 AM



Page 1

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 12/21/09 Start Qty: 160.00



Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 160.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2230	Rev <i>F</i> <i>G</i>
-------	-----------------------

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"
Batch: *B44529*

OK 09/12/21

160

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio D2230-1
(Check for crack while loading into the machine.)
2- deburr rough edges

OK BB 10/01/05

160

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK BB 10/01/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2230-1 PAR #: N/A Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AS Date: 10.01.19
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>54755</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.01.11	110	Thickness on some parts as low as 0.737 (0.003 under tol). R.C. Blanks were cut on an angle	GP 10.01.11 per 451042	Acceptable x 9	SP 10/01/11	SL 10/01/11	GP 10.01.11 per 451042-17	S 10/01/11

NOTE: Date & initial all entries

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Page 2

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Item Name: Lug

Start Date: 12/21/09 Start Qty: 160.00



Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 160.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 10/01/11



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-01-12 160 0



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

SL 10-01-12 160 0



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54755

December 21, 2009 9:04:31 AM



Page 3

Item ID: D2230-1

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Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 12/21/09 Start Qty: 160.00



Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 160.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

1113170

0.00

0.00

Memo

START TIME: 2:00pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 2:30pm

=> Mf 10-01-12

X160

170



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

B2 10-01-12

160

180



Packaging

Packaging

Identify as per dwg & Stock Location: 476

Memo

0.00

0.00

10-1-14 160sl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54755

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Page 4

Item ID: D2230-1

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Setup Start

Revision ID:

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Item Name: Lug

Start Date: 12/21/09 Start Qty: 160.00

Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 160.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/15

mf

10-1-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 21, 2009 9:04:22 AM

Page 1

Work Order ID: 54755



Parent Item: D2230-1



Parent Item Name: Lug

Start Date: 12/21/09

Required Date: 12/31/09

Comments: IPP RevE: take out D2230-1p DD 09.12.09 verified by:EC

Start Qty: 160.00

Required Qty: 160.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423		Manufactured	No			110	f	621.0747	11.5032			



Lug Extrusion



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

621.0747379

43722

175.629406

→ 44529

22.39

45800

423.055332

11.5032 *OK 09/12/21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

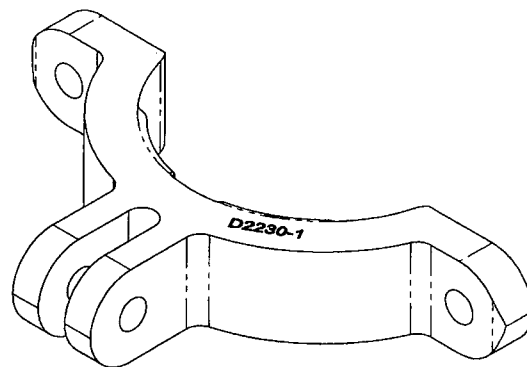
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	54783
Description: Mounting Lug		Part Number:	D2230-1
Inspection Dwg: D2230	Rev: F		Page 1 of 1

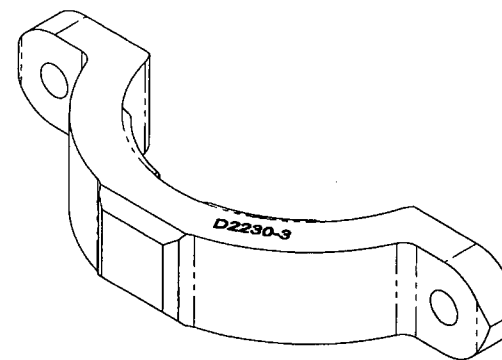
FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	[Signature]



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

*u/w
54755*

RELEASED
01/06/5M



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN		BW	
DRAWN		AJS	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2230	REV. G
TITLE MOUNTING LUG	SCALE NTS
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8 7 6 5 4 3 2 1

D

C

B

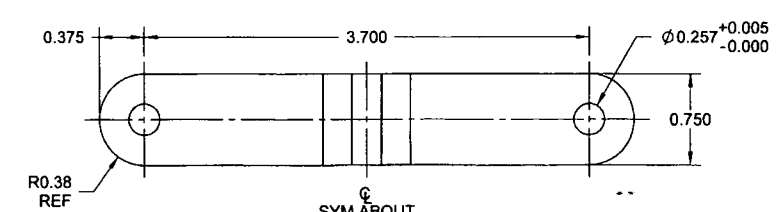
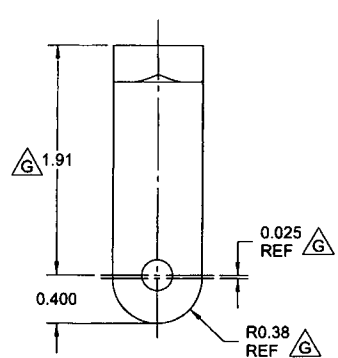
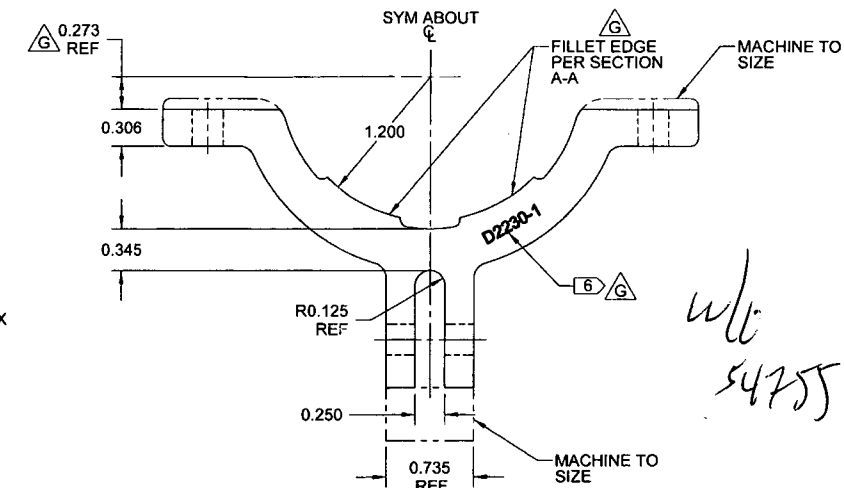
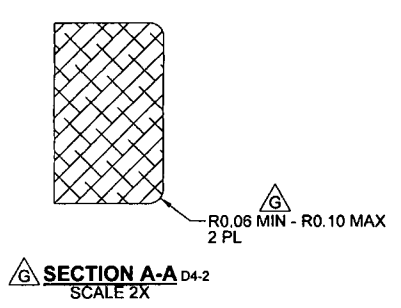
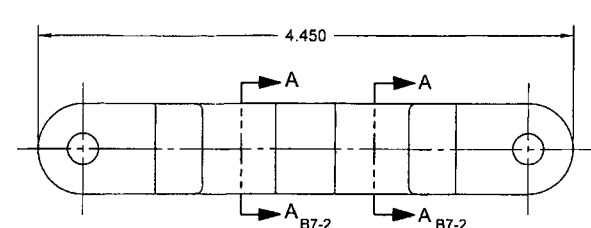
A

D

C

B

A



D2230-1 MOUNTING LUG

RELEASED
09/06/75 M

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2230	REV. G
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 2 OF 3
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

C

B

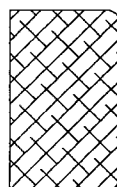
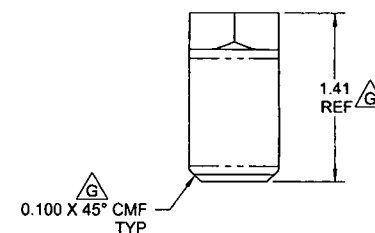
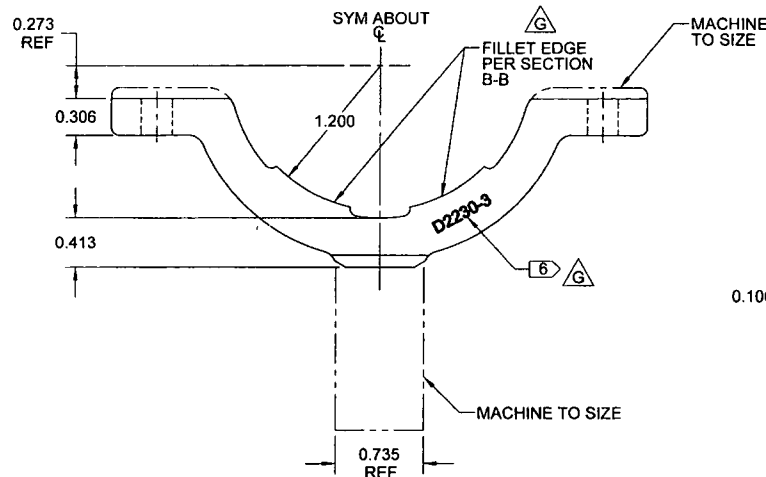
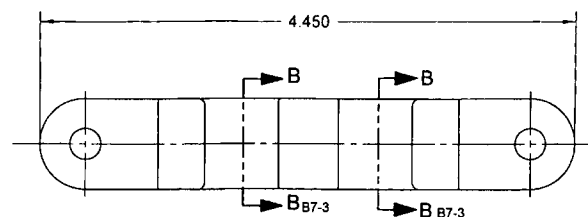
A

D

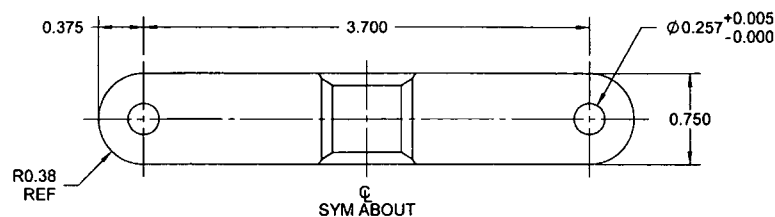
C

B

A



SECTION B-B D4-3
SCALE 2X
R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

54755

RELEASED
09/06/25 M

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		MOUNTING LUG	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1